

# Work Order ID 75865

**\*75865\***

Page 1

Thursday, November 17, 2011 4:13:33 PM

Item ID: K10111 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, Skidtube 206  
 Start Date: 11/1/2011 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 12/9/2011 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: *[Signature]* Date: 11-17 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>	<i>SS</i>							
DSI 9583	A								
K10111	B								
100		0.00							
<b>*100*</b>	DOCUMENT CONTROL								
DC	<b>Memo</b>	0.00							
Document Control	Photocopy bluefile & type labels per PPP FOR D206-642-111 CHG006 FOR D206-642-113 CHG002	K10111 CHG003							
110	Pick Kit	0.00							
<b>*110*</b>									
Packaging	<b>Memo</b>	0.00							
Packaging									

*ml* 12 01 06 (4)  
*JA* FORM L5 12-1-5  
 (4)

*Sp* 12-01-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 75865****\*75865\***

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Item ID: K10111

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 12/9/2011 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00				<u>12</u>	<u>12</u>	<u>01</u>	<u>06</u> (4)
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
130		0.00							
<b>*130*</b>	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP K10111								
	PPP D206-642-111								
	PPP D206-642-113								
	Location: <u>PLS</u>								
	PPP rev: <u>PLS</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

12/1/1012/1/10MF  
12-01-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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**\*75865\***

**\*K10111\***

**Required Date:** 12/9/2011

**Required Qty: 4.00**

IPP REV:G

IPP REV:H 11.11.14

AS PER DSI9583 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN5-10A		Purchased	No				Each	872.0000		16			
*AN5-10A*													
Bolt									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST337		872							
					116704	11							
					118191	59							
					119547	802							
AN5-11A		Purchased	No				Each	1,599.000		16			
*AN5-11A*													
Bolt									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST337		21							
					117313	2							
					118191	19							
				ST518		1578							
					119512	1578							
AN3-41A		Purchased	No			110	Each	1,655.000	18	32			
*AN3-41A*													
Bolt									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				st510		1655							
					119042	1655							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

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Thursday, November 17, 2011 4:13:37 PM

Work Order ID: 75865

**\*75865\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

AN4-6A

Purchased

No

110

Each

5,062.000

12 48

**\*AN4-6A\***

Bolt

\*\*

SP

Location

Loc Qty

Loc Code

ST356

62

119127

62

ST516

5000

119017

5000

110

Each

489.0000

1 4

AN4C5A

Purchased

No

**\*AN4C5A\***

BOLT

\*\*

SP

Location

Loc Qty

Loc Code

FP-B

49

112243

49

ST355

440

112243

340

119017

100

110

Each

511.0000

2 8

AN6-44A

Purchased

No

**\*AN6-44A\***

Bolt

\*\*

SP

Location

Loc Qty

Loc Code

ST343

7

119127

7

st510

504

119036

504

110

Each

1.0000

1 4

D206-651-041

Manufactured

No

**\*D206-651-041\***

206A/B GHW

\*\*

B 76580. SP

4x.

Location

Loc Qty

Loc Code

FG125

1

74002

1

SP 12-01-06.

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 75865

**\*75865\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

D2652

Manufactured No

110

Each

743.0000

16

64

**\*D2652\***

Bushing

\*\*

B76132 - 64xSP

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

699

73835

579

73836

120

Manufactured No

110

Each

18.0000

2

8

D2661-1

**\*D2661-1\***

Saddle, LH Fwd Aft Out 206

\*\*

B76750 8x SP

Location

Loc Qty

Loc Code

MEZZ

5

64559

5

ST435

13

73838

10

73841

1

76516

2

Manufactured No

110

Each

20.0000

2

8

D2662-1

**\*D2662-1\***

Saddle, LH In 206

\*\*

B76770 7x  
B76771 1x  
SP 12-01-06

Location

Loc Qty

Loc Code

ST435

10

73846

1

74479

9

ST476

10

74481

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 75865

**\*75865\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

nhf  
x4  
D2712  
**\*D2712\***  
Set Screw

Manufactured No

110

Each

2,551.000

{10 40

\*\*

SP

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

2501

71160

1

73837

500

76065

2000

40K

Manufactured No

110

Each

100.0000

2 8

\*\*

B76751 SP

nhf  
x4  
D2884  
**\*D2884\***  
Saddle Spacer

Location

Loc Qty

Loc Code

FG

10

29453

10

ST025

90

73823

90

Manufactured No

110

Each

126.0000

2 8

\*\*

B76752 SP

12-01-05

nhf  
x4  
D2885  
**\*D2885\***  
Saddle Spacer

Location

Loc Qty

Loc Code

FG

10

29199

10

ST025

116

73824

116

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Thursday, November 17, 2011 4:13:37 PM

Work Order ID: 75865

**\*75865\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

D3413-1

Manufactured No

110

Each

94.0000

1 4  
\*\*

4

**\*D3413-1\***

Ring

Location

Loc Qty

Loc Code

ST368

2

73821

2

ST420

2

66387

1

70773

1

ST469

88

73822

88

ST473

2

71041

2

MS21042L3

Purchased

No

110

Each

8,781.000

18 32  
\*\*

32

**\*MS21042L3\***

Nut

Location

Loc Qty

Loc Code

ST300

255

117441

16

117885

35

118451

5

118927

199

ST516

6000

119017

6000

ST518

2526

119075

2526

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

Thursday, November 17, 2011 4:13:37 PM

Work Order ID: 75865

**\*75865\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

110

Each

11,520.00

12

48

**\*MS21042L 4\***

Nut

\*\*

80

Location

Loc Qty

Loc Code

ST300

558

117441

51

117601

374

118451

133

ST516

5962

119017

5962

ST518

5000

119075

5000

48x

MS21042L6

Purchased

No

110

Each

1,484.000

2

8

**\*MS21042L 6\***

Nut

\*\*

80

Location

Loc Qty

Loc Code

ST300

484

117677

25

118384

5

118927

48

118968

406

ST518

1000

119075

1000

8x

NAS1149C0463R

Purchased

No

110

Each

1,379.000

1

4

**\*NAS1149C0463R\***

Washer

\*\*

80 12-01-05

Location

Loc Qty

Loc Code

FP-B

1

115358

1

ST297

1378

117735

378

119097

1000

4x

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

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Thursday, November 17, 2011 4:13:37 PM

Work Order ID: 75865

**\*75865\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0363J

Purchased

No

110

Each

4,466.000

8

32

**\*NAS1149D0363.I\***

\*\*

Washer

## Location

## Loc Qty

## Loc Code

ST019

16

117505

16

ST295

3000

119537

3000

ST298

1450

117601

148

118077

1

118612

55

118968

1246

NAS1149D0463J

Purchased

No

110

Each

12,710.00

24

96

**\*NAS1149D0463.I\***

\*\*

Washer

## Location

## Loc Qty

## Loc Code

ST019

25

118179

25

ST298

299

116025

16

116805

0

117291

1

117460

2

118179

17

118384

249

118612

3

119042

11

ST407

12386

119075

10000

119097

2386

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 75865

\*75865\*

Parent Item: K10111

\*K10111\*

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0563J

Purchased

No

110

Each

5,153.000

8

32

\*NAS1149D0563.I\*

Washer

\*\*

Location

Loc Qty

Loc Code

ST296

2000

119546

2000

ST298

3153

118206

2153

118614

1000

NAS1149D0663J

Purchased

No

110

Each

2,598.000

14

16

\*NAS1149D0663.I\*

Washer

\*\*

Location

Loc Qty

Loc Code

ST407

2598

119075

2598

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

## 4.2 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES)

ITEM	QTY -113	QTY -114	QTY -151	QTY -149	PART NUMBER	DESCRIPTION
	X				D206-642-113	SKIDTUBE INSTALLATION, LH
		X			D206-642-114	SKIDTUBE INSTALLATION, RH
	1	1	X		D206-642-151	SKIDTUBE
				X	D206-642-149	RUN-ON LANDING WEARPLATE KIT
	1	1			D206-651-041	* 206 GHW ADAPTER <sup>(2)</sup>
1			1		D3804-041	SKIDTUBE ASSEMBLY
2A			6		D2651-1	* PLUG <sup>(1)</sup>
2B			6		D2651-3	* O-RING <sup>(1)</sup>
3			1		D2646	* AFT CAP <sup>(1)</sup>
4			2		MS27039-1-08	* SCREW <sup>(1)</sup>
5			2		NAS1149D0332J	* WASHER <sup>(1)</sup> (OR AN960JD10L)
6	1				D2661-1	SADDLE, FWD OUT, LH
6		1			D2661-2	SADDLE, FWD OUT, RH
7	1				D2662-1	SADDLE, FWD IN, LH
7		1			D2662-2	SADDLE, FWD IN, RH
8	1				D2661-1	SADDLE, AFT OUT, LH
8		1			D2661-2	SADDLE, AFT OUT, RH
9	1				D2662-1	SADDLE, AFT IN, LH
9		1			D2662-2	SADDLE, AFT IN, RH
10	8	8			AN3-41A	BOLT
11	16	16			D2652	BUSHING
12A	8	8			MS21042-3	NUT (OR MS21042L3)
12B	8	8			NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4			AN5-7A	BOLT
14	4	4			AN5-7A	BOLT
15	8	8			NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12			AN4-6A	BOLT
17	24	24			NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12			MS21042-4	NUT (OR MS21042L4)
20A			1	1	D3805-041	FWD WEARPLATE ASSY
21A			1	1	D3807-1	* GASKET <sup>(3)</sup>
22A			1	1	D3805-045	AFT WEARPLATE ASSY
23A			1	1	D3807-5	* GASKET <sup>(4)</sup>
26A			7	7	AN3-36A	BOLT
26B			7	7	NAS1149D0363J	WASHER (OR AN960JD10)
26C			7	7	MS21042-3	NUT (OR MS21042L3)
26D			14	14	D3873-1	BUSHING
27				2	D2649	SPACER
28	2	2			AN6-44A	BOLT
29A	2	2			MS21042-6	NUT (OR MS21042L6)
29B	4	4			NAS1149D0663J	WASHER (OR AN960JD616)
34	1	1			AN4C5A	BOLT
35	1	1			NAS1149C0463R	WASHER (OR AN960C416)
36	1	1			D3413-1	RING
37	10	10			D2712	SET SCREW
38	2	2			D2884	SPACER
39	2	2			D2885	SPACER

- NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3804-041 ASSEMBLY ABOVE  
(2) NOT INSTALLED AS PART OF SKIDTUBE. USED TO MODIFY OEM GROUND HANDLING WHEELS  
(3) DENOTES THAT PART IS INCLUDED WITH D3805-041 ASSEMBLY ABOVE  
(4) DENOTES THAT PART IS INCLUDED WITH D3805-045 ASSEMBLY ABOVE

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Revision: 0  
Date: 11.06.15

REFERENCE ONLY

## DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-642 REV. O AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 4

REF FAA STC: SA00475SE

REF CANADIAN STC: SH98-4

REF EASA STC: EASA.IM.R.S.01320

### PROCEDURE:

FOR D206-642-113/-114 SKIDTUBE INSTALLATION KITS, IT HAS BEEN DETERMINED THAT AN5-10A (FWD) AND AN5-11A (AFT) BOLTS ARE MORE APPROPRIATE BOLT LENGTHS FOR ATTACHING THE SKIDTUBES TO THE CROSSTUBES THAN THE AN5-7A BOLTS PREVIOUSLY PROVIDED IN THE KITS.

#### 4.2 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES)

##### 32.12 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES)

ITEM	QTY. -113	QTY. -114	PART NUMBER	DESCRIPTION
			D206-642-113	SKIDTUBE INSTALLATION, LH
			D206-642-114	SKIDTUBE INSTALLATION, RH

### IS:

13	4	4	AN5-10A	BOLT
14	4	4	AN5-11A	BOLT

### WAS:

13	4	4	AN5-7A	BOLT
14	4	4	AN5-7A	BOLT

FOR FURTHER DETAILS REFER TO PAGE 22, DETAIL A OF IIN-D206-642 REV. O, OR PAGE 30, DETAIL A OF ICA-D206-642 REV. 4.

A	NEW ISSUE	AJS	11.11.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE USA, INC</b> KENT, WA	
DRAWN	AJS		
CHECKED	90	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9583	SHEET 1 OF 1
APPROVED	140	TITLE	SCALE
DE APPR.	140	BOLT SUBSTITUTION	NTS
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